

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000107**Date Inspected:** 20-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector was present to witness procedure qualification (PQR) HP200746-3 as requested by ZPMC. The test plate was welded in the 1F (flat) position, using the submerged arc welding (SAW) automatic welding process. The welding consumable electrode is identified as 4.8mm diameter, specification AWS A5.23, classification ENi5 (LA-85) and MIL800-HPN flux. The welding was performed in accordance with AWS D1.5 and appeared to comply with the contract documents. Caltrans QA Inspector assigned lot number B49-014-07. See Caltrans Welding Witness Report (TL-6032), dated March 20, 2007 for additional information.



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Summary of Conversations:

At 0900 hours, ZPMC Quality Assurance Inspector, Mr. Hu Gang Lui met with Caltrans QA and stated that ZPMC would be performing procedure qualification testing at ZPMC testing facility at 0930 hours, PQR HP200746-3.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike
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Quality Assurance Inspector

Reviewed By:	McClary, David
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QA Reviewer
